

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003078**Date Inspected:** 19-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:****Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:****Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Sun Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

This Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for observation of Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. This QA inspector observed ZPMC workers performing various functions relative to the fabrication of the OBG Deck Panels. These functions include; closed rib press forming, drilling holes in connection areas, PJP bevel preparation, closed rib splice welding, closed rib diaphragm fit-up and FCAW welding of splices, closed rib to deck plate fit-up and tack welding and the PJP welding of closed ribs to deck plates. Deck Panels DP-331-001 and DP-304-001 were completely welded on gantry 2 and DP602-001 was tack welded and in the ready position for welding on gantry 1.

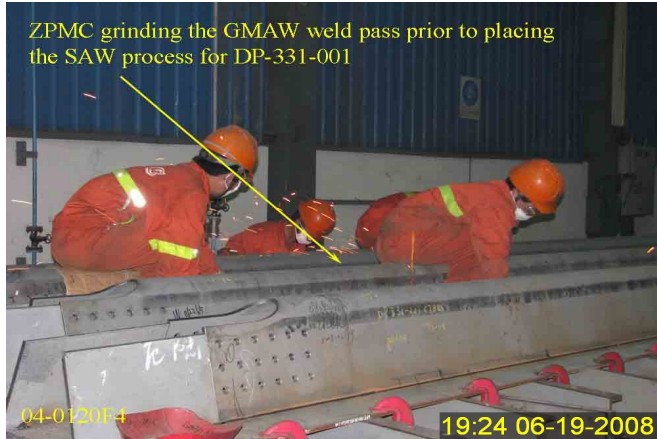
This QA inspector received Notification of Witness Inspection number 557 from ZPMC for Final Ultrasonic Testing (UT) of internal diaphragm plates for U-ribs DP542-001, DP606-001 and DP582-001. Upon arrival to perform ultrasonic verification, ZPMC was in the process of performing their UT testing for these areas; upon completion the UT technician informed this QA inspector that the weldments were acceptable. This QA inspector proceeded to perform 10% verification on the noted weldments and determined by testing that the weldment appeared to be within compliance. Also noted for UT verification this date was in the OBG assembly for segment number SEG 3AE BP6A to BP5A and BP6A to BP4A. This QA inspector proceeded to perform 10% verification on the noted weldments and determined by testing that the weldment appeared to be within compliance. A TL-6027 will be generated for these locations.

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## WELDING INSPECTION REPORT

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### Summary of Conversations:

As Noted Above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Riley, Ken	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon, Albert	QA Reviewer

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